

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018317**Date Inspected:** 18-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the abf submitted UT Notification No 11182010-2.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by abf Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as butt joint between bottom plate to bottom plate transverse splice weld joint from outside only located on 13bw+13cw. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows: OBW13C-001.

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the abf submitted UT Report No ut-13w-002 r1.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by abf Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as butt joint between side plate to side plate transverse splice weld joint located on 13bw+13cw at counter weight side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not

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find any Rejected indication at scanning area. The Weld Designation is as follows: OBW13C-003.

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) repair welding of weld joint SB021-096-020 located on OBG Suspender bracket. ZPMC welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F) - Repair, which is used as per Welding Repair Report (WWR) B-WWR-17107.

Flux Core Arc Welding (FCAW) repair welding of weld joint SB021-096-020 located on OBG Suspender bracket. ZPMC welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F) - Repair, which is used as per Welding Repair Report (WWR) B-WWR-17107.

FCAW repair welding of welds joint SB021-096-004 located on OBG Suspender Bracket SB096E. ZPMC Welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F) - Repair, which is used as per Welding Repair Report (WRR) B-WWR-17106.

FCAW repair welding of welds joint SB018-100-008 located on OBG Suspender Bracket SB100W. ZPMC Welder is identified as 062783. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-1G (1F) - Repair, which is used as per Welding Repair Report (WRR) B-WWR-17098.

FCAW repair welding of welds joint SB018-100-004 located on OBG Suspender Bracket SB100W. ZPMC Welder is identified as 062783. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-1G (1F) - Repair, which is used as per Welding Repair Report (WRR) B-WWR-17097.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint BK004B3-001-040, 041, 051 and 052 located on stringer to deck plate joint of OBG Bike path. ZPMC welder is identified as 202338. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G (1F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2223.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint BK004B3-001-014 and 015 located on stringer to deck plate joint of OBG Bike path. ZPMC welder is identified as 202338. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G (1F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2228.

Visual Inspection after Blast

OBG Segment 12AW

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This QA Inspector performed a preliminary random visual inspection on OBG Segment 12AW, after the grit blast of the interior components of the deck planes, floor beams, bottom plates, side plates and corner assemblies of this segment panel point PP109 to P112. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer

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